Work Order ID April-11-13 2:24:09 PM		· .					Page	1				
Item ID: D4092- Revision ID: Item Name: Mainten	l ance Step	A	Accept	*N9000	740	100) *	Setup	Start Stop	*N:	S1* S2*	_
Start Date: 4/11/13 Required Date: 4/11/13 Reference:	,	*12* *12*		Cust Item IE Customer:) :							
	ss Plan: MC5	Date: <u>/3-04-/7</u>		Date of the Date o	te:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	_
Draw Nbr D4092 100 *100* Bandsaw Jeaspa Bandsaw	Revision Nbr B Cut blanks as per folio Cut 30.250" long Memo		0.00	St	13-04.	-22	12	.ø			-	,
*110 *110 HAAS I HAAS CNC vertical machine	Memo #I Mill as per D Dwg Rev: Folio rev:		0.00	J/ S/13-04	<i>42</i> 2		<u></u> 12	- <i>J</i>	>			_

Deburr

NCR: Y	es / No	ı			WORK ORDER NON-	CONF	ORN	//ANCE / UP	DATE			٠,
								•		QA Closed:	Date:	
Work Orde	r:	1			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
		i	· · · · · · · · · · · · · · · · · · ·		Rework	7		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	o.	1			Scrap	1	N	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		1			Use-as-is] [Therm	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	lo	!			Work Order Update]		Large Fab	Composite]	Supplier	
Root				Descri	iption of work order update	Init	tial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		1										
Equip/Tooling	_	,	1 1				Ī				,	
Operator	_	i										
Material		ı										
Setup	_	,										
Other		Ī										
Process		[
Supplier	_		1 1			ł]	
Training												
Unapproved	<u> </u>	1	<u>1</u>					2004		<u> </u>	<u> </u>	1
		1				FAULT (CATE	JURY				
Landir F	ng Gear	ſ		_	General	П	rain			Ovalized		Pressure/Forced
-	Bending	- 1 C		\s_\(-\)	Bend BOM/Route		raiii ardwa	ro	-	Over/Under	tolerance	Temperature/Cure
}	Centre No	ot Conce	ntric to U	" ³ -	Broken/Damaged	-		on Incomplete		Part Incorre	-	Weld
ŀ	Cracks Crushed/	Crimand		_	Burrs	—		ions Incomplete/	(Unclear	Part Lost/M	 	Wrong Stock Pulled
}	Cuffs	Crimped	-	\vdash	Contamination	 		nance	Officient	Part Moved	_	J W Tong Stock T allea
ŀ	Heat Trea	,		-	Countersink	\vdash	lislabe		<u> </u>	Positioned V		
}	Inspectio		Tubo	-	Cut Too Short	├ ──┤	lisread		}-	Power Loss/		Other
}	Ripples in		Tube	-	Drill Holes	⊢ ⊣	ffset	ı	L.			
}	Torque W	'	Evtrusion		Drawing	├ ──		Calibration				
į		AGAC2 III (- Vri 021011	<u> </u>		\square	4.01	and actor				

Outside Dimensions

DQA: _____ Date: ____

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord April-11-13 2:2		9622		*996	322*							Page 2
Item ID: Revision ID: Item Name:	D4092-1 Maintenance	: Step		Accept	*N900	040	100)*	Setup	Start Stop	14.	S1* S2*
Start Date: Required Date Reference:	4/11/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item II Customer:	D:						
Approvals:		lan:	Date:	Tooling: SPC (Y/N):	Da	te:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I 120 *120* QC Quality Control	D	Operation Description QC2- Inspect parts off ma	achine FAI/FAIB	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qt		Reject Number	Insp. Stamp
130 *130* QC Quality Control		QC8- Inspect parts - seco	nd check	0.00	·			12				<u>JLB-4</u>

140

140 HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

12 NG 13.4-25

NCR:	Yes / N	О	I			WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE			
	•		!								QA Closed:	Date	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
						Rework]		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No				<u> </u>	Scrap		l l	Machining	Small Fab	√	d. Eng. Coor.	Quality
			i			Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	No					Work Order Update			Large Fab	Composite]	Supplier	
Root			1		Descri	ption of work order update		nitial	Ad	ction	Sign &		
Cause	Da	e St	e'p	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Setup			ı										
Other			!										
Process		,	1								1		
Supplier	\vdash												
Training		1											·
Unapproved	<u> </u>							T CATE	GORY		1	1	
Landi	ng Gear			<u></u>		General	AUI	CAIL	GONT				
Latiui	Bend	ng			•	Bend	Г	Grain			Ovalized		Pressure/Forced
		e Not Co	ncer	ntric to (_{2/5}	BOM/Route	\vdash	Hardwa	ire	-	Over/Under	tolerance	Temperature/Cure
	Crack				⁵ , –	Broken/Damaged	-	4	ion Incomplete	-	Part Incorre	 	Weld
		ed/Crim	ped	·	<u> </u>	Burrs		4 '	ions Incomplete	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs	, , , , ,	,			Contamination		Mainte	•		Part Moved		
	⊢	Treat				Countersink		Mislabe	eled		Positioned V	Vrong	
		ction Stri	ip in	Tube	T	Cut Too Short		Misread	d		Power Loss/	'Surge	Other
'		es in Ben				Drill Holes		Offset					
		e Waves		xtrusion	,	Drawing		Out of	Calibration				

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 99622 April-11-13 2:24:09 PM				*996			Page 3		
Item ID: Revision ID: Item Name:	D4092-1 Maintenance	Sten		Accept	*N900	<u>04010</u>)* Setup	p Start Stop	*NS1* *NS2*
Start Date: Required Date Reference:	4/11/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:			IV.57
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:	Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I 155 *155* HandFinish Hand Finishing	D	Operation Description Wing Walk as per dwg Q Memo	S1005 4.4 Batch 25/	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code		ty I	Reject Insp. Number Stamp
160 *160* QC Quality Control		QC3- Inspect Part Finish Memo		0.00	`.		121		M-13/04/2
170 *170* Packaging		Identify as per dwg & Sto	ck Location:	0.00	-] 13/5/	128 D

Packaging

			1									DQA:	Dat	te:	
NCR:	Yes	/ No	1			WORK ORDER NON-O	100	VFORM	MANCE / UP	DATE		-		•	2.3
		,	ı						•		QA	Closed:	Da	te:	
Work Ord	or.		1			DISPOSITION				AGAINST DE	PAR	RTMENT/	PROCESS		
WOIR OIG	٠				<u> </u>	Rework	1		Skid-tube	Crosstube	7		Water Jet	\neg	Engineering
Part I	No.		!			Scrap	1		Machining	Small Fab	1	Proc	d. Eng. Coor.		Quality
			T			Use-as-is		Therm	noforming	Finishing]	Rec/Stor	e/Packaging		Other
NCR I	No.		· · · · · · · · · · · · · · · · · · ·			Work Order Update]		Large Fab	Composite			Supplier		
Root			!		Descri	ption of work order update		Initial	Ac	tion	S	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	n	QC Inspector
Doc/Data															
Equip/Tooling			· i				į								
Operator			<u>'</u>												
Material			i i											1	
Setup			!	}											
Other			,												
Process			!									ļ			
Supplier			-											ı	
Training			1												
Unapproved											<u> </u>				
			1			F	AUL	T CATE	GORY						
Landi	ng C	ear	1			General	_	-		_	_			_	
		Bending	1			Bend		Grain			Ov	alized		<u></u>	Pressure/Forced
		Centre No	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re		Jov	er/Under	tolerance	L	Temperature/Cure
		Cracks	ĺ			Broken/Damaged	L	Inspecti	on Incomplete		Par	rt Incorrec	ct	L	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	'Unclear	Par	rt Lost/Mi	ssing	<u></u>	Wrong Stock Pulled
		Cuffs	i			Contamination] Mainte	nance		Par	rt Moved			
		Heat Trea	it ¦			Countersink] Mislabe	led		Pos	sitioned V	Vrong		
	П	Inspection	n S <mark>trip in</mark>	Tube		Cut Too Short		Misread	i		Pov	wer Loss/	Surge		Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		9622		*996	522*							Page 4	
Revision ID:	D4092-1 Maintenand	ce Step		Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	4/11/13 4/11/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:							
Approvals:	Process QC:	Plan:	Date:	Tooling: SPC (Y/N):		ate: ate:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center II 180 *180* QC Quality Control)	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Re Qt	-	Reject Number	Insp. Stamp	+

134-29

			1								DQA:	Date:	
NCR:	Yes	/ No	 			WORK ORDER NON-O	CON	NFORM	MANCE / UP	DATE	QA Closed:	Date:	
			; [-o <u>-</u> ,		DISPOSITION				AGAINST DE			
Work Orde Part I NCR I	٠ . ۷o		!			Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Pro	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause		Date	Step	Qty)	ption of work order update or Non-conformance	1	nitial ief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
			1			F	AUL	T CATE	GORY				
Landi	ng G	Gear	ı J			General		·					
		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in Torque W	Crimped. it i n Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/U enance eled	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \ Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Turning S	1		" <u>-</u>	Finish		1	Sequence				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Picklist Print

April-11-13 2:24:09 PM

Work Order ID:

99622

Parent Item:

D4092-1

Parent Item Name:

Maintenance Step

Start Date: 4/11/13

Required Date: 4/11/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD 639 ILM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ED2761-108 Extrusion (HPK)		Manufactured	No			100	f	710.9935	2.5 _36.0	31.578947 200 '	J.	£13-0	4-22
				Location MAT007		<u>Loc Oty</u> 710.99354	<u>Lo</u>	c Code					
				8020	06~ }	710.99354			36.	0001			

NCR:	Yes	/ No	! !			WORK ORDER NON-	COI	NFORI	MANCE / UPI	DATE	QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	dance of the control
Part I	-		1 : 1 i			Rework Scrap Use-as-is Work Order Update		. 1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				0.		ption of work order update	1	Initial	Act		Sign &		
Cause		Date	Step	Qty	· · ·	or Non-conformance	Cr	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling			; !									•	
Operator	Ш												
Material			:	İ					1				
Setup	Ш	:	<u> </u>	İ									
Other	Ш		i										
Process	Н		1						ļ				
Supplier	Ы												
Training	Н		ı										
Unapproved			<u> </u>				1				<u> </u>		
							AUI	T CATE	GORY				
Landi	<u> </u>		i			General	_	1			1	_	7
	_	Bending	i		_	Bend	<u> </u>	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
		Centre No	ot Conce	ntric to	^{D/S}	BOM/Route	<u> </u>	Hardwa		-	Over/Under		Temperature/Cure
	\vdash	Cracks	!			Broken/Damaged		4	ion Incomplete	_	Part Incorred	 	Weld
		Crushed/0	Crimped.			Burrs	\vdash	4	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	${f oxedown}$	Cuffs	1		<u></u>	Contamination	_	Mainte		<u> </u>	Part Moved		
	\vdash	Heat Trea	1		_	Countersink		Mislabe		ļ	Positioned V		7
		nspection		Tube		Cut Too Short	_	Misread	i		Power Loss/	Surge	Other
,	\bigsqcup '	Ripples in	Bend			Drill Holes		Offset					
		Torque W	aves in E	extrusio	n 1	Drawing	1	Out of 0	Calibration				

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

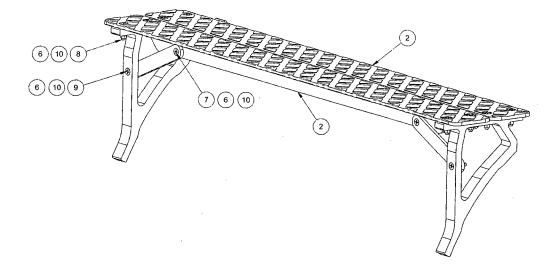
DART AEROSPACE LTD	Work Order:	99622
Description: Maintenance Step	Part Number:	D4092-1
Inspection Dwg: D4092 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30.06	+/-0.030	30.050	V			
0.19	+/-0.030	. 185			Ven	Mos
1.25	+/-0.030	1.265			17	
. 1.38	+/-0.030	1.375	<u> </u>		21	
0.25	+/-0.030	.245			,,	
R0.25	+/-0.030	.250			R-6	
2.50	+/-0.030	2.497	/		Verm	ML-06
Ø0.201	+0.005/-0.001	.201	✓		, ,	
0.30	+/-0.030	.2985			• i	
4.78	+/-0.030	4.780			, i	
1.69	+/-0.030	1.690			ii	
2.69	+/-0.030	2.960			14	
∺ 0.030	+/-0.010	, 035			97	
0.20	+/-0.030	.203			1/	
0.50	+/-0.030	.500			11	
0.035	+/-0.010	.033			. 1	
0.390 x 100°	+/-0.010 x 0.5°	.395 X108			1.6	
1.500	+/-0.130	1.500			"	·
0.50	+/-0.030	,506			1,	
1.25	+/-0.030	1.250			,,	
0.69	+/-0.030	. 480			ci "	
0.38	+/-0.030	.328	_		١(
0.69	+/-0.030	.680			71	
					· . ·	

		10 1			
	ured by: 🗻		Audited by:	Preliminary Approval:	
	Date: 13	04-22/13/04/23	Date: 13-4-24	Date:	
Rev	Date	Change		Revised, by	Approved/
Α	12.05.15	New Issue		KJ dal	17.11

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



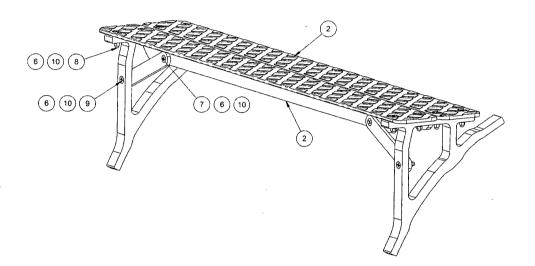
the Ob ... DCOPY DESCRIPTION OF THE PARTY A THE STICE 99.622 MUS 13-84-12

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/R\	
/ 5 \	

В	REDRA	REDRAWN; LOWERED FOR AESTHETICS			11.07.27		
Α	NEW IS	SUE		RF	10.09.16		
REV.			DESCRIPTION	BY	DATE		
DESIG	N	RF	DART AEROSPACE	AZII	INC		
DRAWN R		RF	KENT, WA				
CHECK	ED	140	DRAWING NO.		REV. B		
MFG. APPR.		91	D4092		SHEET 1 OF 6		
APPRO	OVED	148	TITLE		SCALE		
DE API	PR.	#	MAINTENANCE STEF	ASS	Y NTS		
DATE 11.07.27		7.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THE DODUMENT IS MYNATE AND COMPORTING AND IS EXPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PARMODE OR COMPANIENTED TO ANY OTHER PERSON WITHOUT WITH THE PROMESTED RECOMMENDED AND A PROPERTY AND ANY.				

99622

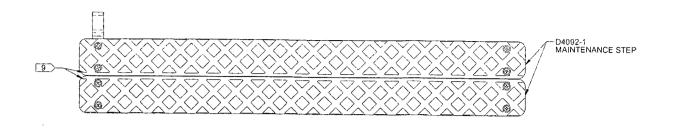
ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
. 3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
. 5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

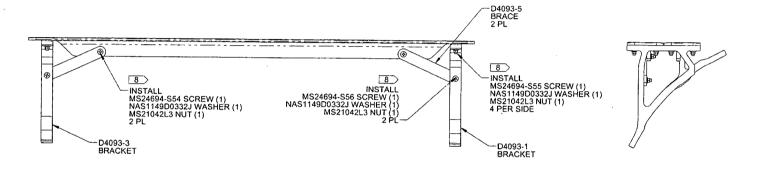


D4092-042 MAINTENANCE STEP ASSEMBLY



DESIGN RF DRAWN RF		DART AEROSPACE USA, INC.		
MFG. APPR.		T D4002	SHEET 2 OF 6	
APPROVED NO		TITLE	SCALE	
DE APPR.		MAINTENANCE STEP ASS'Y	ŅTS	
DATE 11.0	7.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PROVIDE AND COMPROGRITM, MOD IS SUPPLIED ON THE SUPPLIES CONDITION HOT TO BE USED FOR ANY PURPOSE OR COMED ON COMMANCATED TO ANY OTHER PERSON	N THAT IT IS	





D4092-041 MAINTENANCE STEP ASSEMBLY



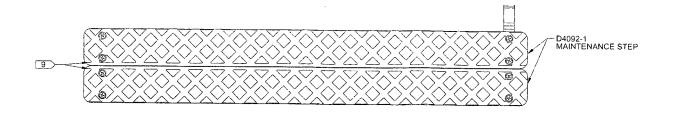
NOTES:	
1) MATERIAL: N/A	4
ON ETRUCKULA LIA	

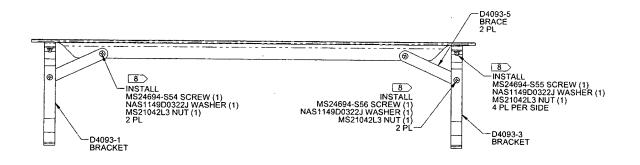
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 5.37 lbs
8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
9) GRIP CUTOUT TOWARD CENTER

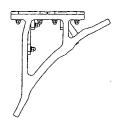
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DESIGN RF DRAWN RF		DART AEROSPACE USA, INC.	
MFG. APPR.	ge/	D4092 SHEET	
APPROVED	140	TITLE	CALE
DE APPR.	-#	MAINTENANCE STEP ASS'Y	NTS
DATE 11.0°	7.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENTS PROVIDE AND COMPOSITIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS	

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D4092-042 MAINTENANCE STEP ASSEMBLY

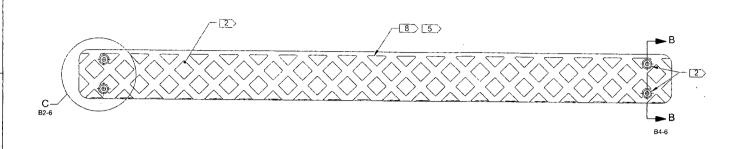
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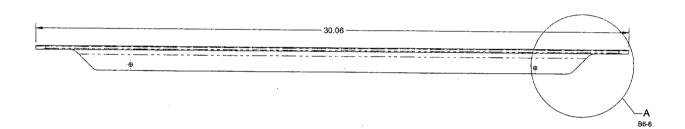
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
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8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
9) GRIP CUTOUT TOWARD CENTER

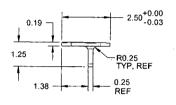
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D4092-1 MAINTENANCE STEP (MAKE FROM D2761 EXTRUSION)

DELEASED 2011-09-22

NOTES:
1) MATERIAL: MAKE FROM D2761 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
6) IDENTIFICATION: N/A
7) WEIGHT: 1.97 lbs
8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45 ° PATTERN 0.38 APART

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DESIGN RF DRAWN RF		DART AEROSPACE USA, INC.	
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